

DART AEROSPACE LTD

Work Order:

21966B

Description: 3" Skidtube Heavy "I Beam"

Part Number:

D2600-7-140

Dwg: D2600 Rev. D1

Qty:

93

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	HA	04.11.25	93
2	PG	Issue P/O: <u>700796</u> a) Extrude as per Dwg D2600 b) Material: 6061-T6 (QQ-A-200/8) c) Minimum yield tensile strength = 35 ksi d) Minimum ultimate tensile strength = 40 ksi e) Minimum elongation = 8% f) Order at 140" long g) Caradon Indalex Tool # MS-18872 h) To be packed per DSK 066 i) Pull test to ASTM standard B221 required. j) Material certification is required	W	04.11.25	93
3	RG	Receive and Inspect for transit damage Ensure certification is attached	CJ	05/01/07	49
4	QC6	Inspect dimensions as per Dwg D2600 Check Pull test as per Dwg D2600 for compliance page attached. Check hardness with Webster tester	CJ	04/11/17	54
5	ST	Identify and Stock	HA	05.02.03	49
6	AC	Cost / part: <u>36.98</u>	HA	05.02.03	49
7	DC	Close W/O <u>36.98</u> Inspect Level 21	HA	05.02.04	49

Rev	Date	Change	Revised By	Approved
A	04.11.25	New Issue	KJ/RF	RF

RELEASED
04.11.25.17



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. D SHEET 1 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1
A	97.01.21	NEW ISSUE	
B	97.09.09	CHANGE MATERIAL SPEC.	
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	
D	98.08.20	INCREASE MIN. UTS TO 40 KSI	
DI	01-04-17	ADD PART NUMBERS + DIE NUMBERS <i>FCP</i>	

RELEASED
18 08 25 DS

GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi

MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi

MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES.

2. BREAK ALL SHARP CORNERS 0.010 MAX.

3. NO TOOLING MARKS.

4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

5. ALL DIMENSIONS ARE IN INCHES.

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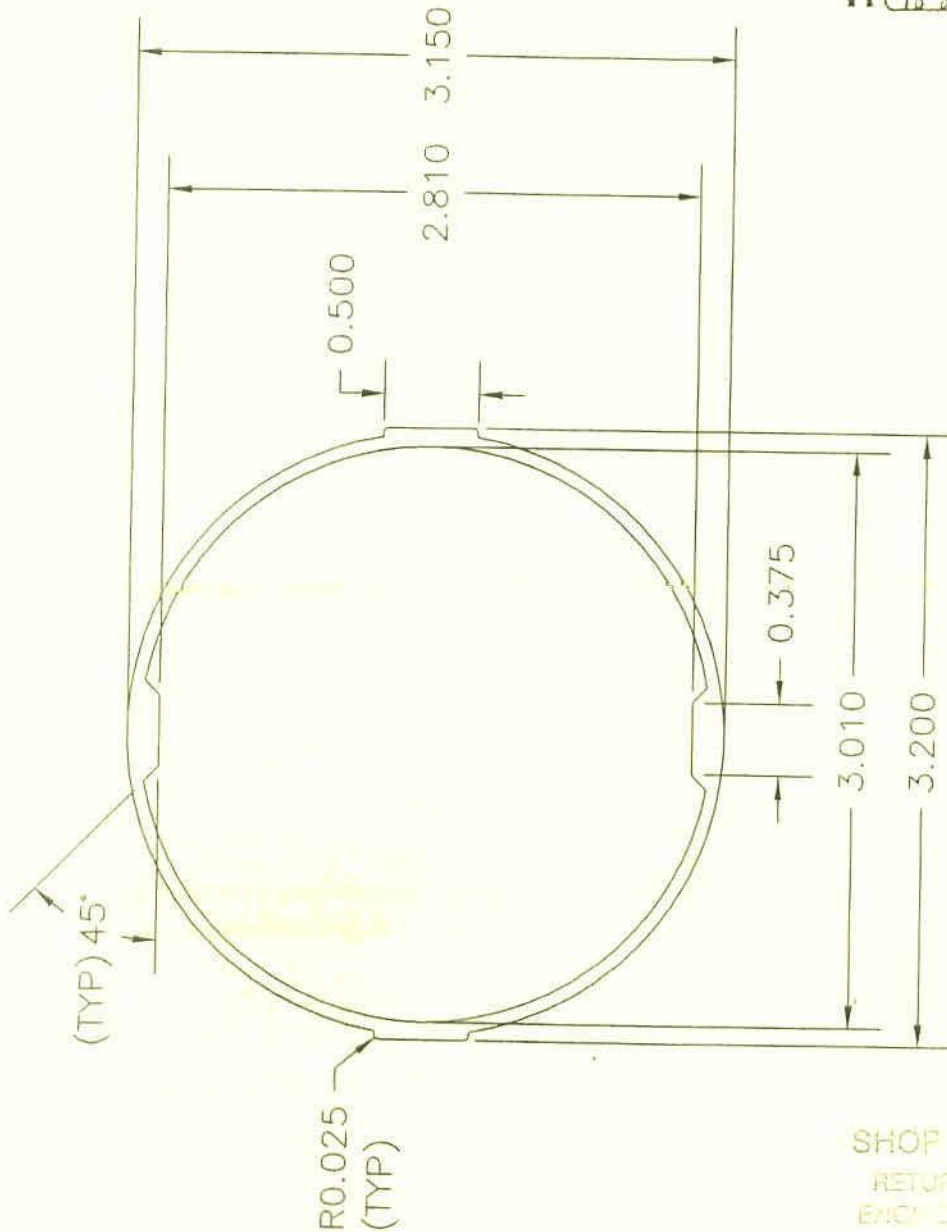
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3-1-12 AMENDMENT
1-1-12 NOTICE

ORDER
NO. 21966



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DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

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98825 DS



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MANUFACTURED WITH CARADON INDALEX DIE # MH-18870
OR BON L DIE # 897121 (PREFERRED CHOICE)
PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 160" LONG)

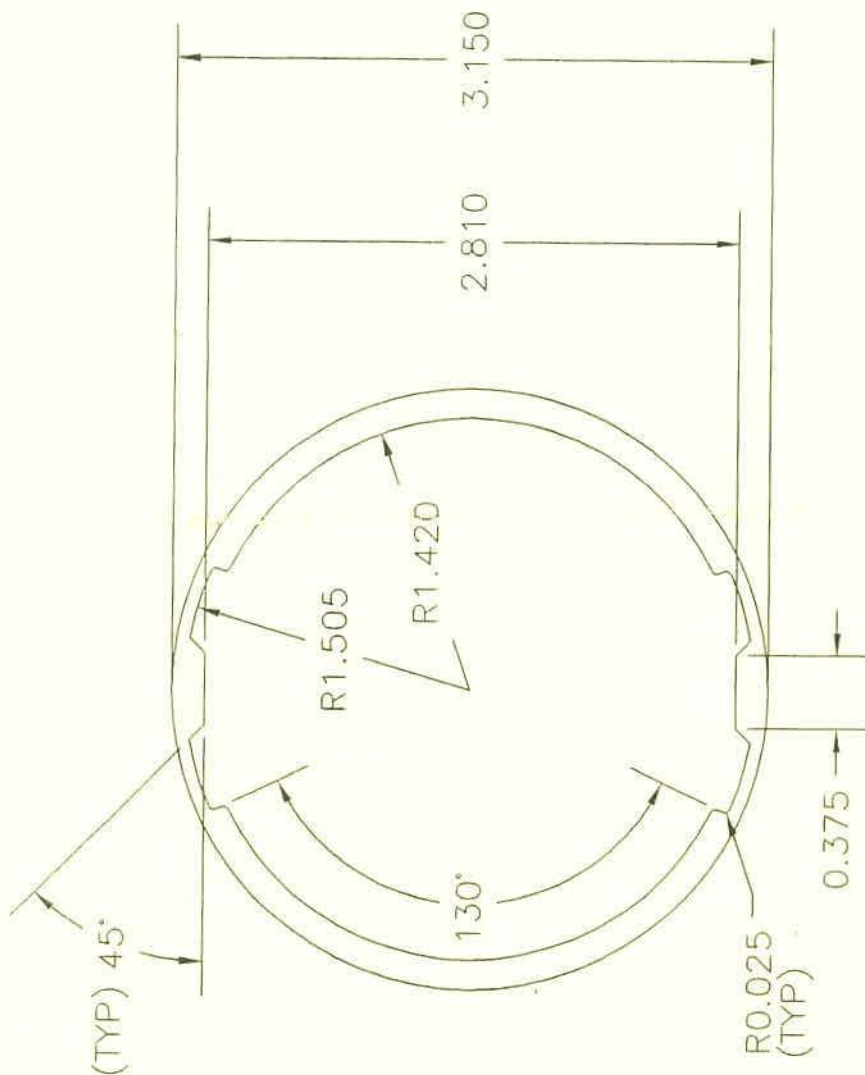


21966



DESIGN <i>DM</i>	DRAWN BY <i>DM</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>CA</i>	DRAWING NO. D2600	REV. D SHEET 3 OF 5
DATE 98.08.20	TITLE EXTRUSION	SCALE 1:1	

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98.8.25 DS



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D2600-3

MANUFACTURED WITH CARADON INDALEX DIE # MH-18859

OR BON L DIE # 897122 (PREFERRED CHOICE)

PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-3-120 IS 120" LONG)

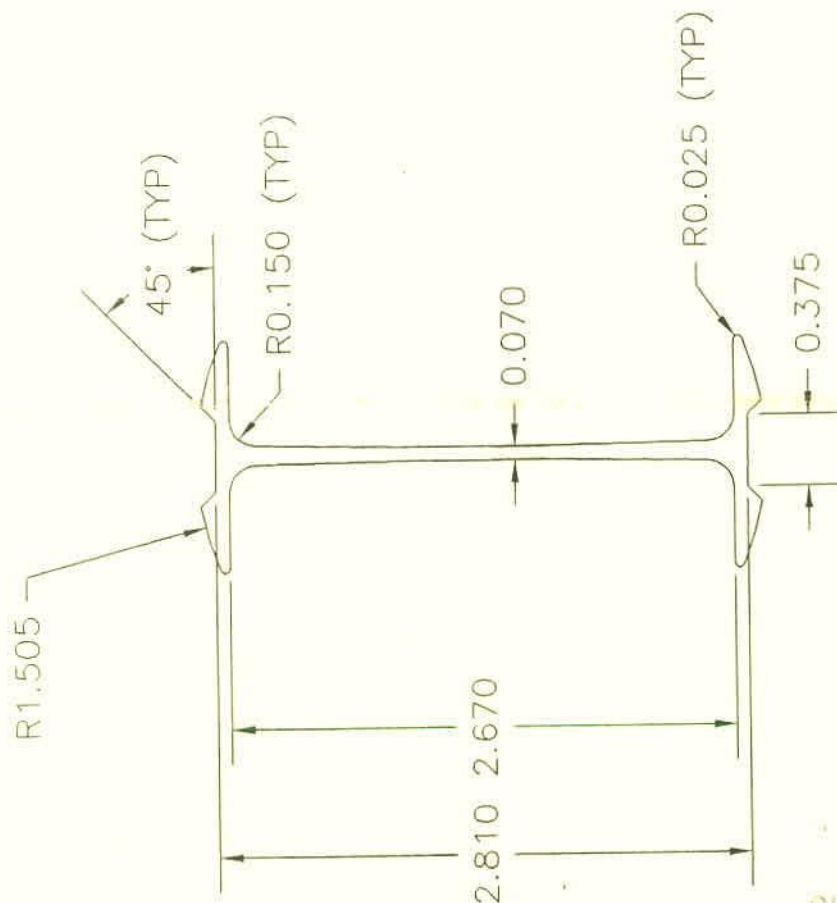


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DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

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98 8 25 DS



D2600-5

MANUFACTURED WITH CARADON INDALEX DIE # MS-18871

PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-5-108 IS 108" LONG)

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WITHOUT NOTICE

WORK ORDER

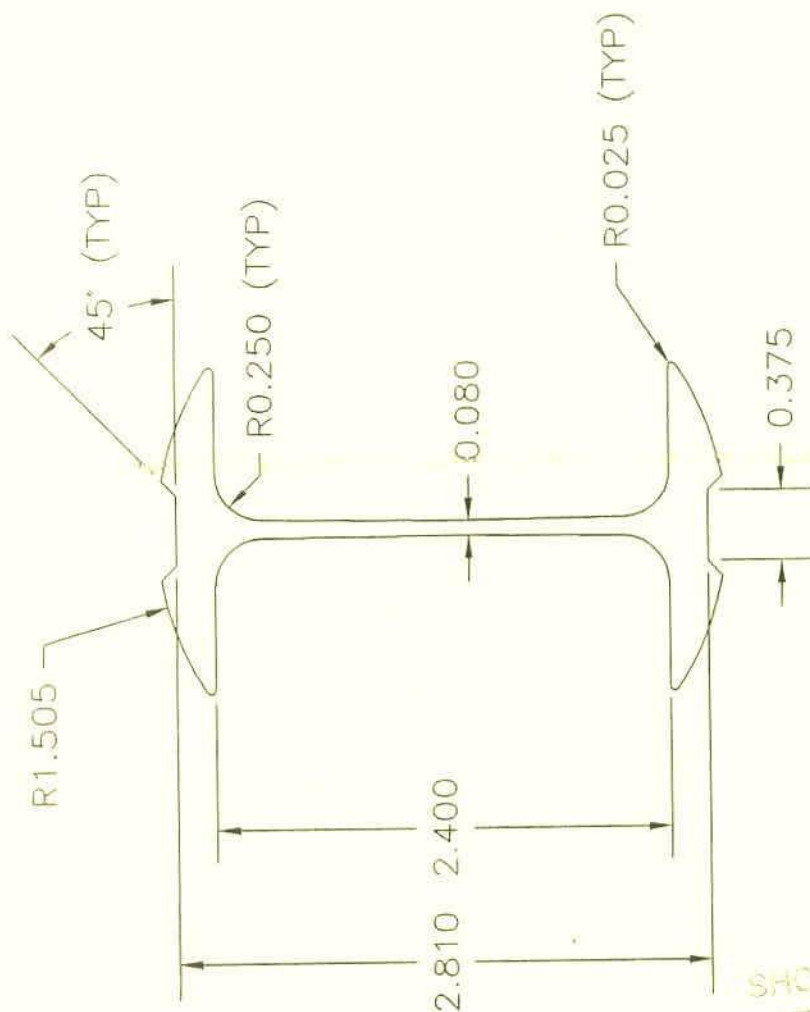
NO. 21966





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DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

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D2600-7

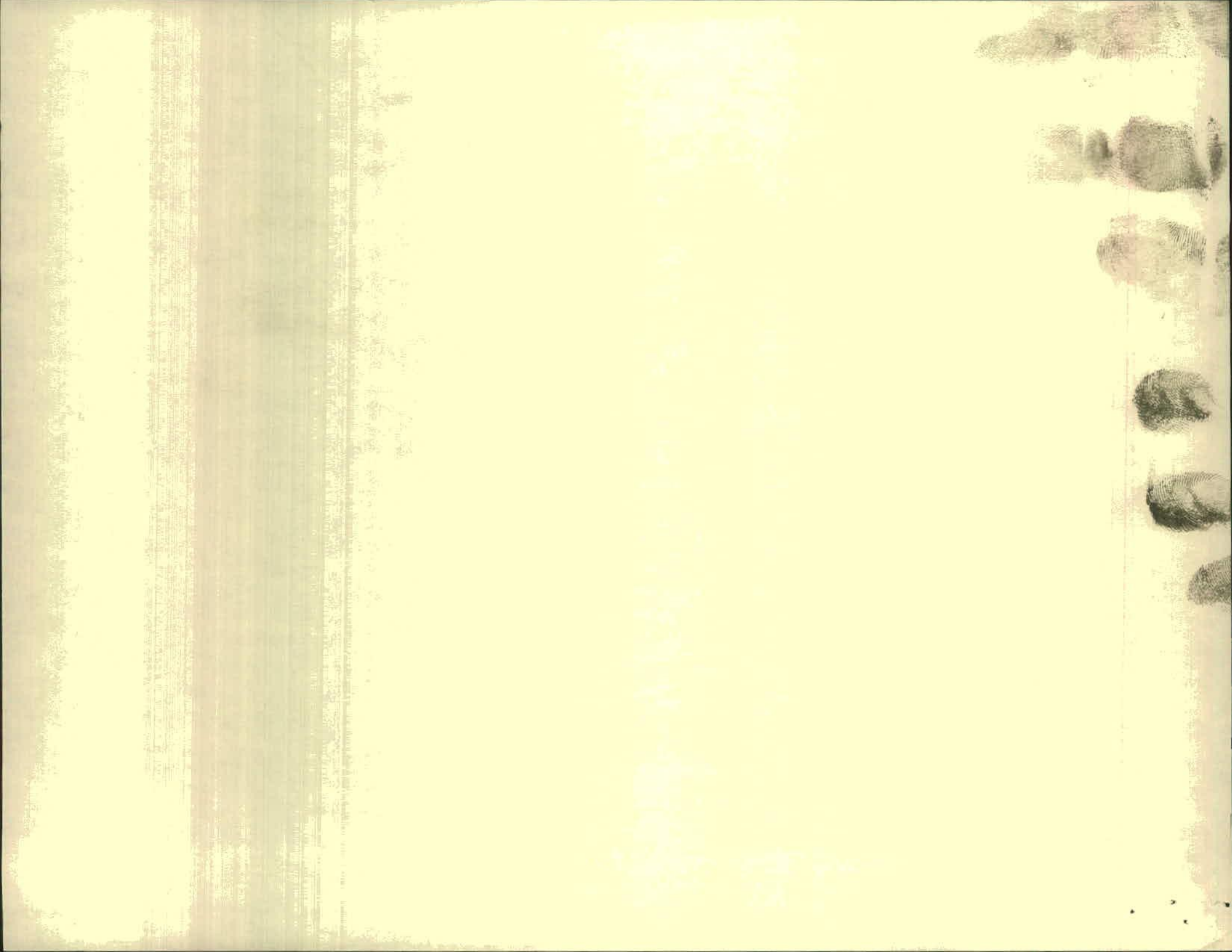
MANUFACTURED WITH CARADON INDALEX DIE # M5-18872
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-7-125 IS 125" LONG)

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REVISION
NOTICE

WORK ORDER

NO. 21966





325 rue Avro
Pointe-Claire QC H9R 5W3

Téléphone (514) 697-5120
Fac-simile (514) 694-8310

Rapport des propriétés mécaniques Mechanical Properties Test Report

Client / Customer : DART AEROSPACE LTD
Adresse / Address : 1270 ABERDEEN STREET
HAWKESBURY ONT,
K6A 1K7

commande Indalex / Indalex order # : 4113326
bon de commande / Purchase order # : 2007196
de matrice / Die # : MS 18872 Description : D-2600-7 Heavy Duty Web
Alliage & trempage / Alloy & temper : 6061 T6
de coulée / Cast # : 4123301-B
de contrôle / Control # : 73756-3

Composition chimique typique / Typical chemical composition :

Si:0.50-0.70/ Fe:0.13-0.25/ Cu:0.15-0.25/ Mn:0.10max / Mg:0.80-1.00 / Cr:0.04-0.14 / Zn:0.05max / Ti:0.05max

Dureté Rockwell E / Rockwell E Hardness : 95 HRE


	Min.requis Min.required	Résultat actuel Actual results
Contrainte élastique Yield stress (psi)	35 000	41 574
Tension ultime Ultimate stress (psi)	38 000	44 809
% élongation dans 2" % elongation in 2"	8	9

Nous certifions que le matériel fourni rencontre les exigences chimiques telles qu'annoncées par l'Association de l'Aluminium ainsi que les exigences de nos procédures de contrôle de qualité.

We hereby certify that the material supplied meets the chemical properties as published by the Aluminum Association, and requirements of our quality control procedures.

Sincèrement vôtre,
Yours truly,

date : 2005/01/05


Alain Gignac
Technicien de la qualité
Quality technician

Indalex Limited

